

# Work Order ID 92664

\*92664\*

Page 1

November-06-12 12:40:00 PM

Item ID: D4095-045 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate Assembly  
 Start Date: 11/14/12 Start Qty: 8.00 \*8\* Cust Item ID:  
 Required Date: 11/19/12 Req'd Qty: 8.00 \*8\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12-11-07 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4095	B								
100	FLOW WATER JET	0.00							
*100*									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg (D4095-5) Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
*110*									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
*120*									
QC	Memo	0.00							
Quality Control									

15  
12-11-19

10 1B12-11-8  
 10 1B12-11-8  
 10

# Work Order ID 92664

**\*92664\***

Page 2

November-06-12 12:40:00 PM

Item ID: D4095-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 11/14/12 Start Qty: 8.00 **\*8\*** Cust Item ID:  
 Required Date: 11/19/12 Req'd Qty: 8.00 **\*8\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00				10			12/6/20
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155Form Joggle as per Dwg D3564 on brake using Jig DT8157								
140	QC5- Inspect part completeness to step on W/O	0.00				10			
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150		0.00				10	0	0	12-11-22
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing	COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 123591								



# Picklist Print

November-06-12 12:40:00 PM

Page 1

Work Order ID: 92664

Parent Item: D4095-045

Parent Item Name: Wearplate Assembly

Start Date: 11/14/12

Required Date: 11/19/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 11.10.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	341.7780	1.03	8.673684	10	11-11-8	

Location

Loc Qty

Loc Code

MAT020

341.778

122245

51.078

122753

52.9

123136

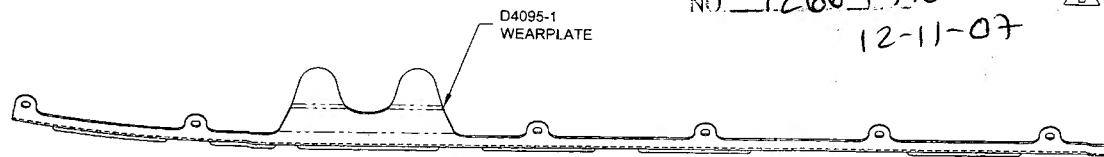
237.8

123136 (10)  
~~123136~~  
~~123136~~  
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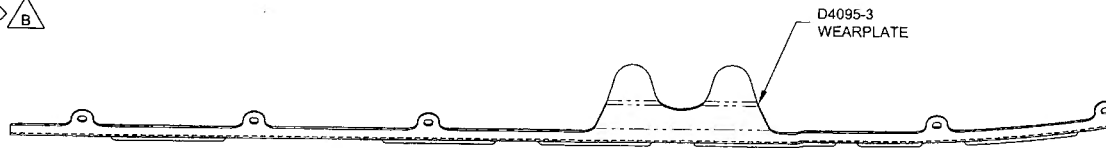
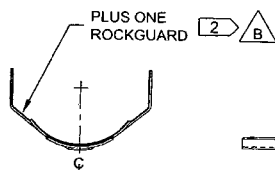
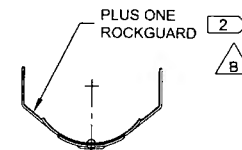


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WITHOUT NOTICE  
WORK ORDER  
NO. 92664 MCT  
12-11-07

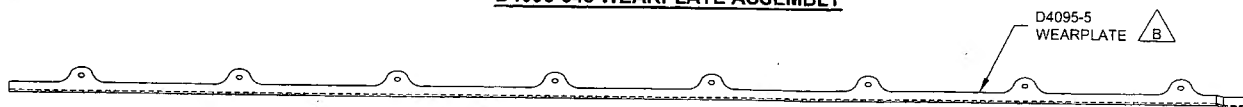
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



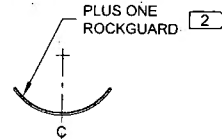
**D4095-041 WEARPLATE ASSEMBLY**



**D4095-043 WEARPLATE ASSEMBLY**



**D4095-045 WEARPLATE ASSEMBLY**

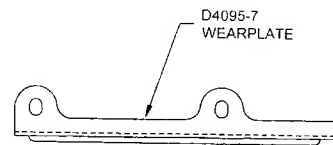


**D4095-041/-043/-045/-047/-049/-051 NOTES:**

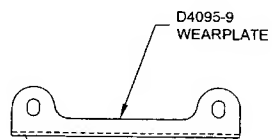
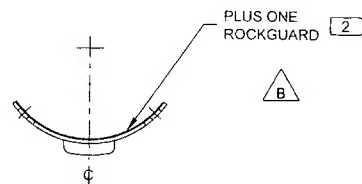
- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND B/N "BXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041 = 3.08 lbs; D4095-043 = 3.08 lbs; D4095-045 = 2.00 lbs; D4095-047 = 0.48 lbs; D4095-049 = 0.42 lbs; D4095-051 = 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT C

B	REVISED D4095-1/-1F/3/3F; 4715 PLUS ONE ROCKGUARD REPLACES D4096-1/-3; ADDED D4095-5/-7/-9/-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

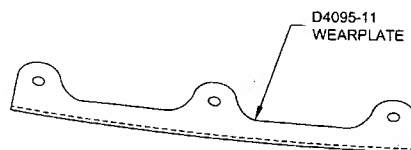
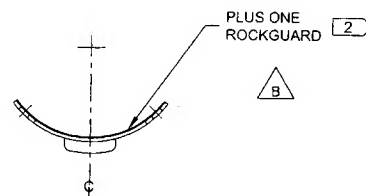
**DART AEROSPACE USA, INC**  
KENT, WA  
DRAWING NO. D4095  
REV. B  
SHEET 1 OF 8  
SCALE NTS  
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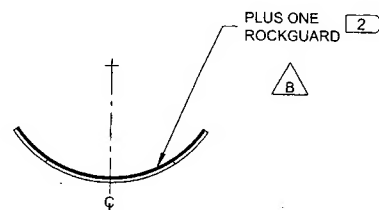
**D4095-047 WEAR PAD ASSEMBLY**



**D4095-049 WEAR PAD ASSEMBLY**

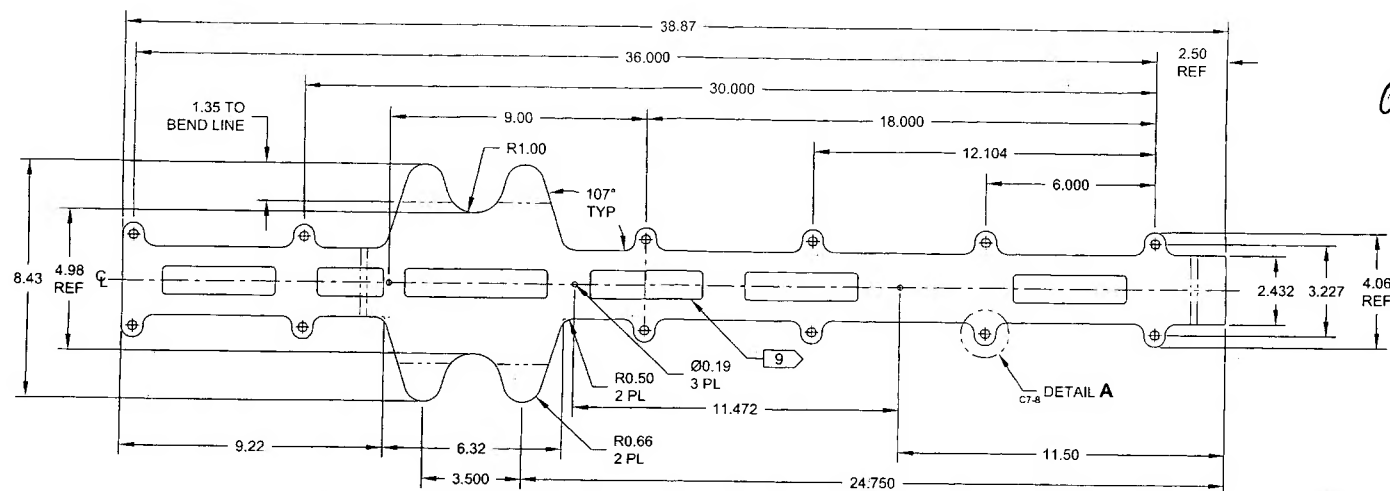


**D4095-051 WEARPAD ASSEMBLY**

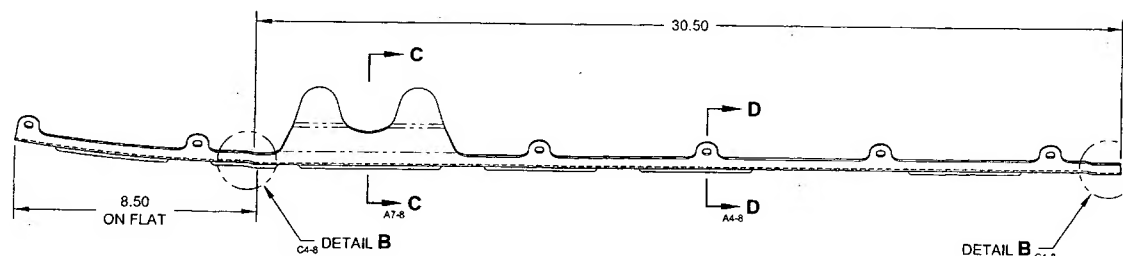


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**D4095-1F FLAT PATTERN**



**D4095-1 BENDING DETAIL**  
(MAKE FROM D4095-1F)

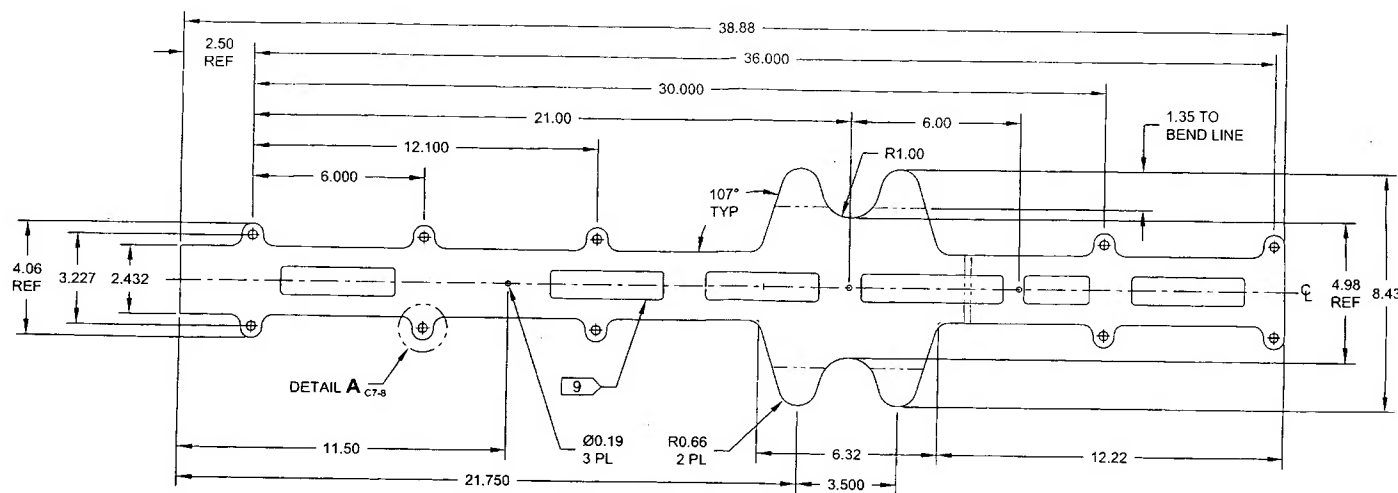
**D4095-1/-1F/-3/-3F/-5/-5F/-7/-7F/-9/-9F/-11/-11F NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240  
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT  $\bar{C}$

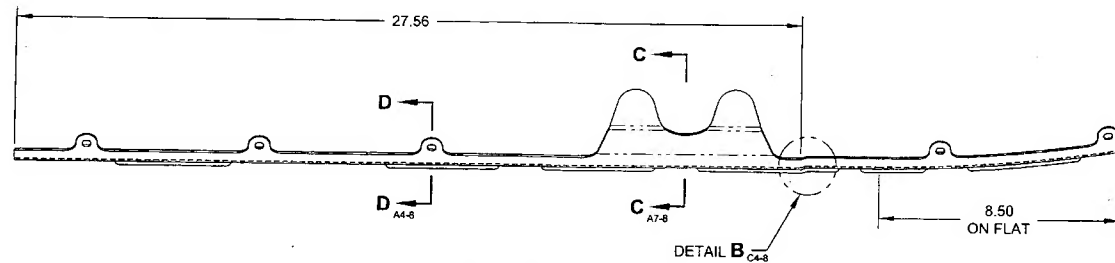
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**D4095-3F FLAT PATTERN** 1

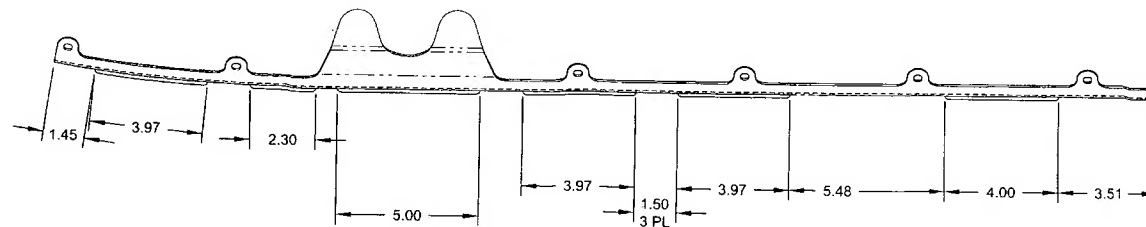


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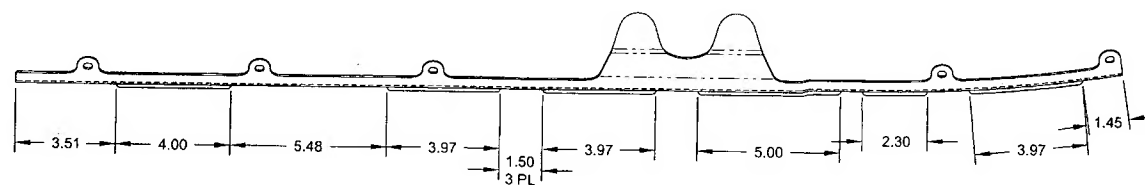
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**D4095-1 WELDING DETAIL** B

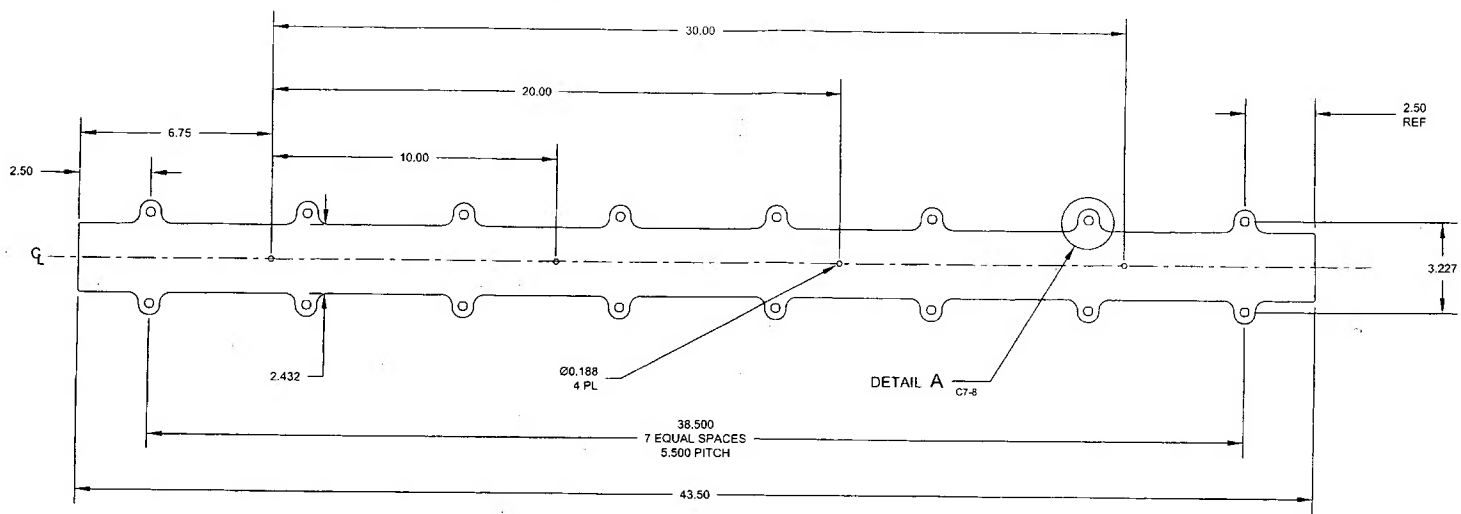


**D4095-3 WELDING DETAIL** B

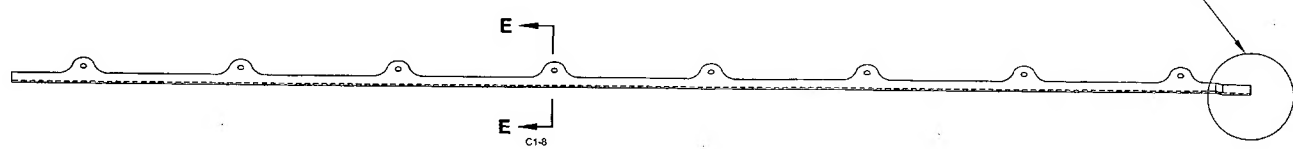
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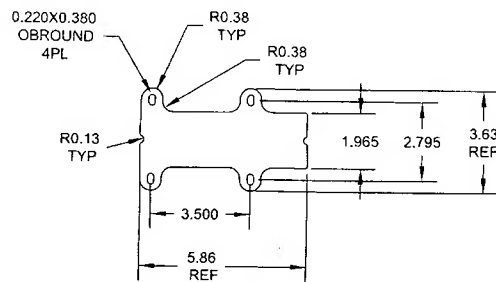
**D4095-5F FLAT PATTERN**



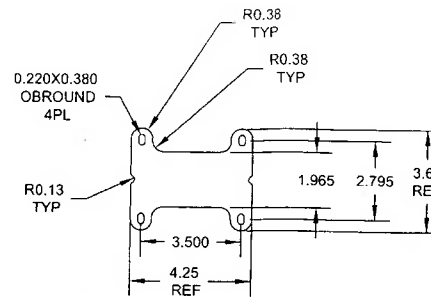
**D4095-5 BENDING DETAIL**  
(MAKE FROM D4095-5F)

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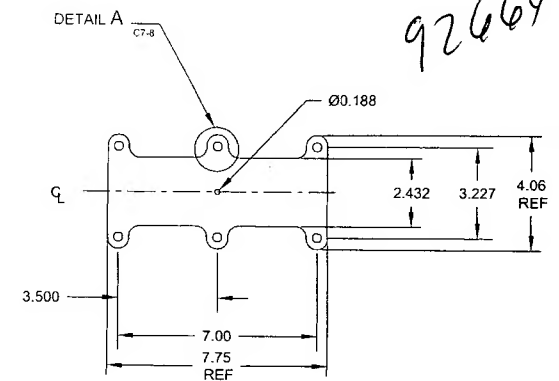
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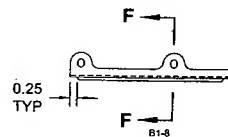
**D4095-7F FLAT PATTERN** 1



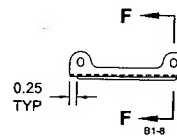
**D4095-9F FLAT PATTERN** 1



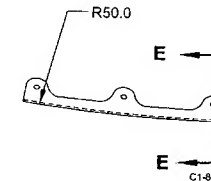
**D4095-11F FLAT PATTERN** 1



**D4095-7 LONGITUDINAL BEND**  
(MADE FROM D4095-7F)



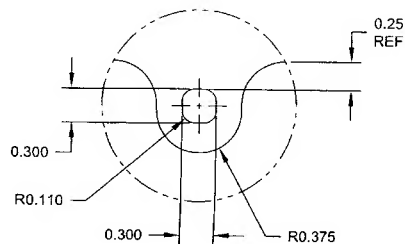
**D4095-9 LONGITUDINAL BEND**  
(MADE FROM D4095-9F)



**D4095-11 BENDING DETAIL**  
(MAKE FROM D4095-11F)

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MFG. APPR.	AP	REV. B SHEET 7 OF 8
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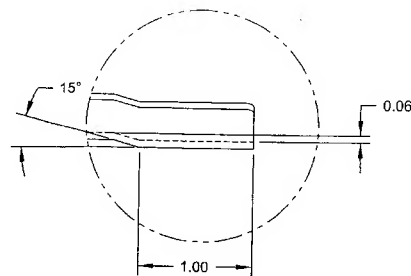
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**DETAIL A: TAB DETAIL**

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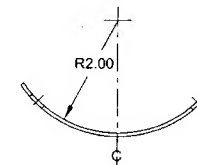
C3-3  
C8-4  
D3-6  
D2-7



**DETAIL B: JOGGLE DETAIL**

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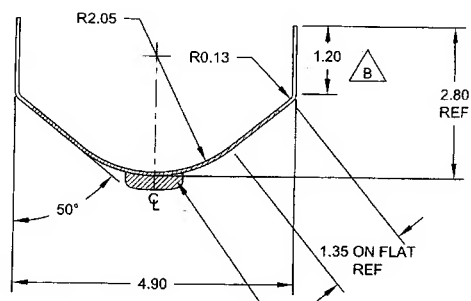
B2-3  
B6-3  
B3-4  
B2-6



**SECTION E-E**

SCALE 2X

B5-6  
B2-7

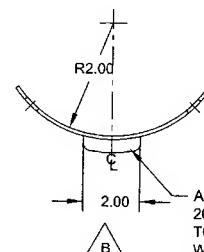


**SECTION C-C**

SCALE 2X

B5-3  
B4-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

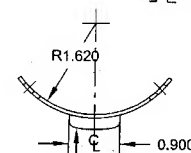


**SECTION D-D**

SCALE 2X

B4-3  
B5-4

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK



**SECTION F-F**

SCALE 2X

B5-7  
B7-7

APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

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2011-10-31  
M

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MFG. APPR.	10	D4095	SHEET 8 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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